

Blue

Work Order ID 52663-1

October 6, 2009 7:40:02 AM

58ht



Page 1

Item ID: D2646

Accept

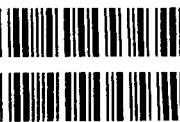


Setup Start



Revision ID: C

Stop



Item Name: Aft Cap

Start Date: 10/06/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/10/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2646	Rev C

100



PURCHASING

Purchasing

Memo

0.00

PL 09-10-4

Purchasing

Issue P/O: 10531 Memo: 11-Spin as per Dwg D2646 12-Material release
note required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

10/10/21 (50)

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120



QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

22 Oct 10/22

counts
(+8)

Work Order ID 52663

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October 6, 2009 7:40:02 AM

Item ID: D2646

Accept



Setup

Start



Revision ID: C

Stop



Item Name: Aft Cap

Start Date: 10/06/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

Small Fab
Memo
1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

140



QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

0.00

carlo
TSO

Memo

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

Work Order ID 52663



Page 3

October 6, 2009 7:40:02 AM

Item ID: D2646

Accept



Setup Start



Revision ID: C

Stop



Item Name: Aft Cap

Start Date: 10/06/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Powdercoat
Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Prarie

B110918

m 09

11

09

20

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

spray paint Delfleet Blue

B110077
B113053

2009-11-12

20

180

Small Fab

Small Fab

Small Fab

0.00

Memo

Install inserts as per Dwg D2646

09-11-12

20

Work Order ID 52663

Page 4

October 6, 2009 7:40:02 AM

Item ID: D2646

Accept



Setup Start



Revision ID: C

Stop



Item Name: Aft Cap

Start Date: 10/06/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

200



Identify as per dwg & Stock Location:

FP-7

0.00

Packaging

Memo

0.00

Packaging

210



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Picklist Print

October 6, 2009 7:40:01 AM

Page 1

Work Order ID: 52663



Parent Item: D2646RevC



Parent Item Name: Aft Cap

Start Date: 10/06/09

Required Date: 10/20/09

Comments:

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased		No		110	Each	3,056.000	100.0000			

Insert

Warehouse

Location

Main Warehouse

ST 10511

Loc Qty

Loc Code

105855

3056

108606

16

111529

52

111779

1488

112772

500

1000

16

BL 09-11-12

D2646PRevC



Aft Cap

Purchased

No

180

Each

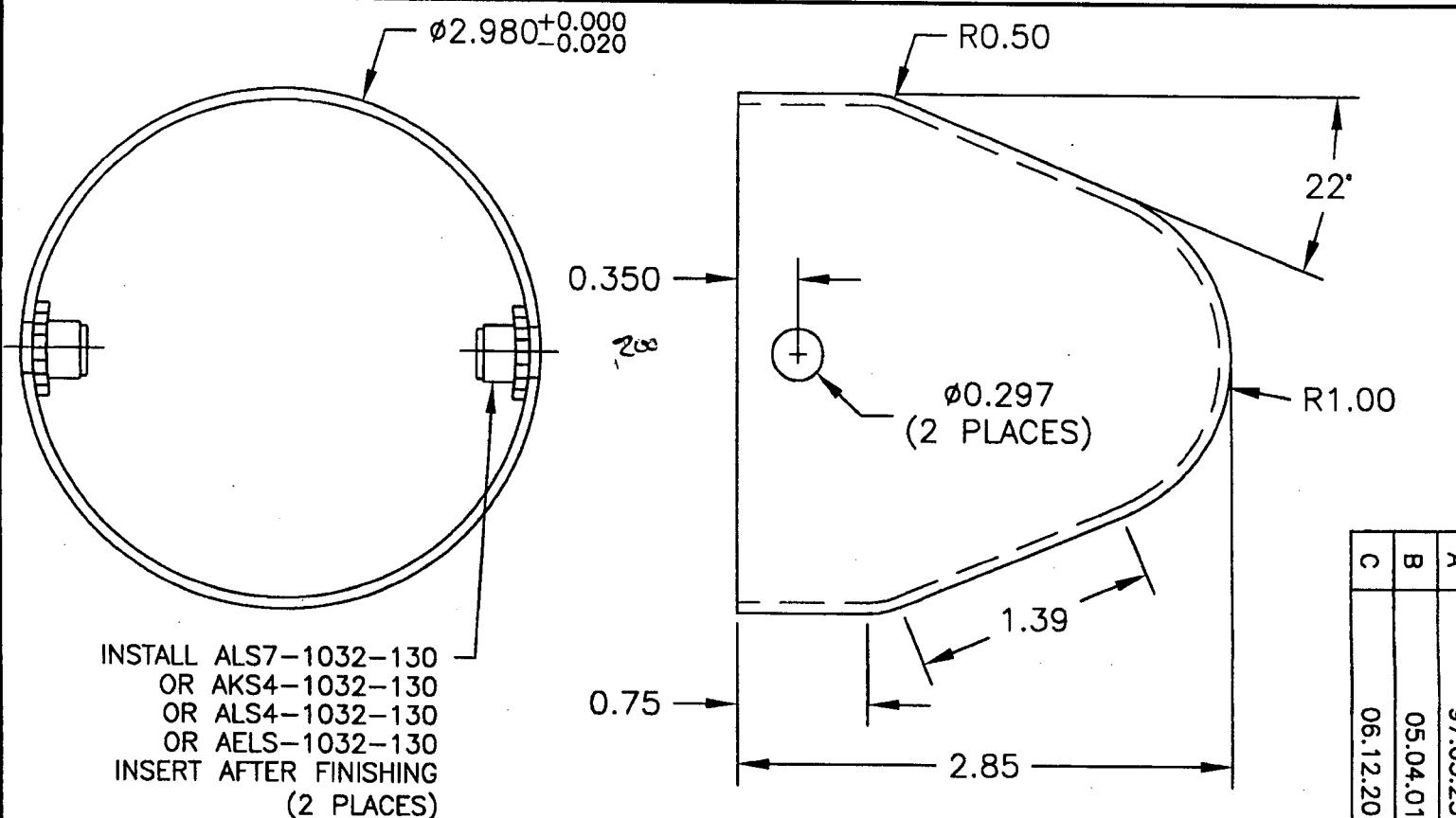
0.0000

50.0000



52663 MR

09-11-12

DART

INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52663

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
DS	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2646
DATE		SCALE
06.12.20		1:1
A	97.03.25	NEW ISSUE
B	05.04.01	CHANGE TO CLOSED INSERTS
C	06.12.20	CHANGE TO OPEN ENDED INSERTS

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Sieg's Manufacturing Ltd.
Metal Spinning and Fabricating

6236 - 205 STREET, Langley, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

Packing Slip

Packing Slip No.: 37189
Date: 10/20/2009
Page: 1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 10531	Sold By: KAULBARS, KALE
Shipped By: FedEx	Ship Date: 10/20/2009
Tracking No.:	

Item No.	Unit	Description	Quantity
D2646P +	EACH	AFT CAPS S 6/10/22	✓ 50

Comment:



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, Langley, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Oct. 20/09

Customer: Dart Aerospace

Packing Slip: 37189

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By:
D2646P	50	14GA	N/A	✓	#2

Notes:

Material Certification Attached: Yes.

PRECISION COIL, INC.

7/10/2007

Post Office Box 2650
U.S. 50 West
Clarksburg, WV 26302
(304) 622-1984
(304) 622-2301

CS 1775

CERTIFIED INSPECTION REPORT

Report No. 31657

Test Date 7/10/2007

Lot # / Heat # / S/O # 76086

Customer Name COPPER & BRASS SALES

Alloy 1100

Customer PO # CS1775

Temper O

Test Specification AMSQQA250/1A &
ASTMB209-06

Gauge (in) .063

S 07/10/07

Width (in) 48

Length (in) 144.000

Net Weight (lbs) 10,522#'s

Test No	Spec ID	YLD (psi)	UTS (psi)	ELONG in 2" (%)
38480	1100-O	5,714	13,038	33.00

6078L-18

ALLOY	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHER		Al
									EACH	TOTAL	
1100	Si+Fe	.85	.05-.20	.05	---	—	.10	—	.05	.15	39.00 Min
ACTUALS											
	.12	.60	.10	-----	-----	-----	.01	-----	.05	.15	REMAINDER

THIS REPORT INDICATES THE CHEMICAL ANALYSIS RANGE TO WHICH THE ITEMS LISTED WERE MANUFACTURED
BASED ON CERTIFICATE OF COMPLIANCE FURNISHED TO US BY THE PRODUCER. WE CERTIFY THEM TO BE
WITHIN THE LIMITS SHOWN. FOR ALLOY 1350 ONLY A MINIMUM ELECTRICAL CONDUCTIVITY OF 62% I.A.C.S.
AT 20 DEGREES CELSIUS IS GUARANTEED.

By: UNK, UNK Date: 7/13/07



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10531

Purchase Order Date 06/10/2009
PO Print Date 06/10/2009

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2646P C	Aft Cap	06/10/2009 Yes	50.00 Each	Yours ppd	\$5.3500	\$267.50

Special Inst: As per DWG D2646 Rev C

PO Total: \$267.50

FAXED
07/10/09
297

**MATERIAL CERTIFICATION
REQD UPON DELIVERY**

**CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY**

Change Nbr: 2

Change Date: 06/10/2009

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable